

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021241**Date Inspected:** 22-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

East Side

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #002 located on 13BE, corner assembly CA3013B. Welder is identified as 067572. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

Weld joint #137 located on 13BE, SEG3019AB. Welder is identified as 066179. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-Tc-U5b-FCM-1.

Weld joint #100 located on 14E, corner assembly CA3013B. Welder is identified as 067572. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

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Flux Cored Arc Welding (FCAW):

Weld joint #011 located on 13CE, SEG3214A-001. Welder is identified as 067571. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Weld joint #028 located on 13AE, SEG3007AH. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #012 located on 13CE, SEG3214A-001. Welder is identified as 067571. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Witness of Ultrasonic Testing (UT)

This QA inspector Witnessed UT performed by ZPMC Quality Control personnel. The member is identified as OBG Component. The component and weld designation identified as follows:

SEGMENT 13A EAST VERTICAL PLATE WELD

SEG3007Z-001 (See attached photo)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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